

Date: Wednesday, 2/22/2006 2:00:37 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 25895	
Estimate Number : 11459	
P.O. Number : N/A	Part Number : D314085
This Issue : 2/22/2006 S.O. No. : N/A	Drawing Number : D3140 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 25893	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 2/24/2006 Qty: 4 Um: Each
Checked & Approved By : SEE ABOVE DATE & USER	
Comment : Est. A 02.04.30 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.3688 sf(s)/Unit Total : 1.4750 sf(s)

M5052H32S.040 SHEET

Batch M 18D19

SB 06/02/22

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Cut as per dwg D3140 26.65" long

Deburr.

No sharp edges

Contour as per dwg form

SB 06/02/22

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06.02.27 (4)
SAD 06102126 (4)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSIONFF 06.02.27 (4)
SAD 06102126 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/03/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/22	2	1 piece was out of tolerance	CP 06.03.01 P QSI 042	Scrap & replace	SB 06/02/22	<u>[Signature]</u> 06-02-23	CP 06.03.01 P QSI 042	<u>[Signature]</u> 06-02-22

NOTE: Date & initial all entries

Date: Wednesday, 2/22/2006 2:00:37 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 25895

Part Number: D314085

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ship Delastek m/06/02/07

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/03/07

Job Completion



u 06-03-01

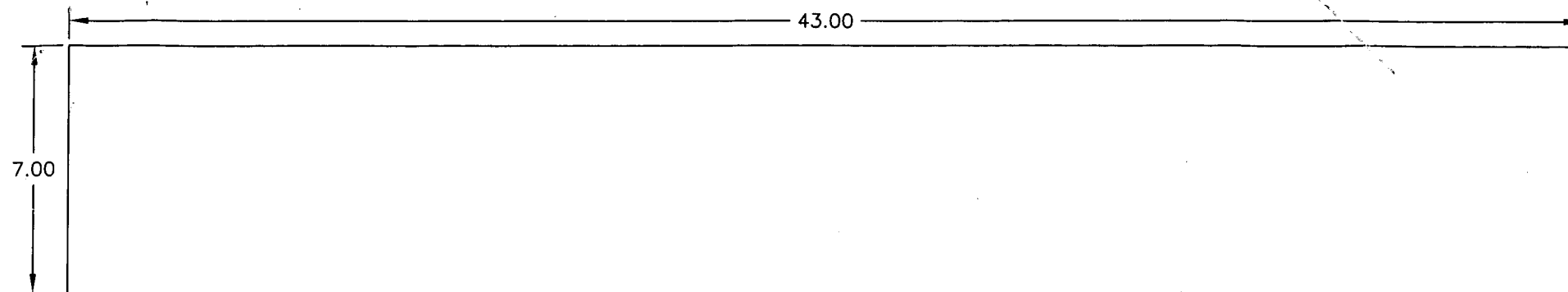
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector


Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

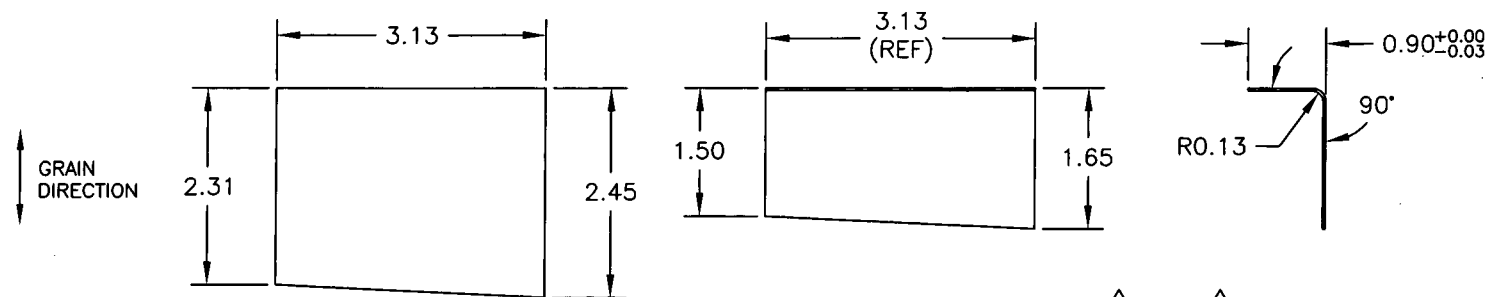
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

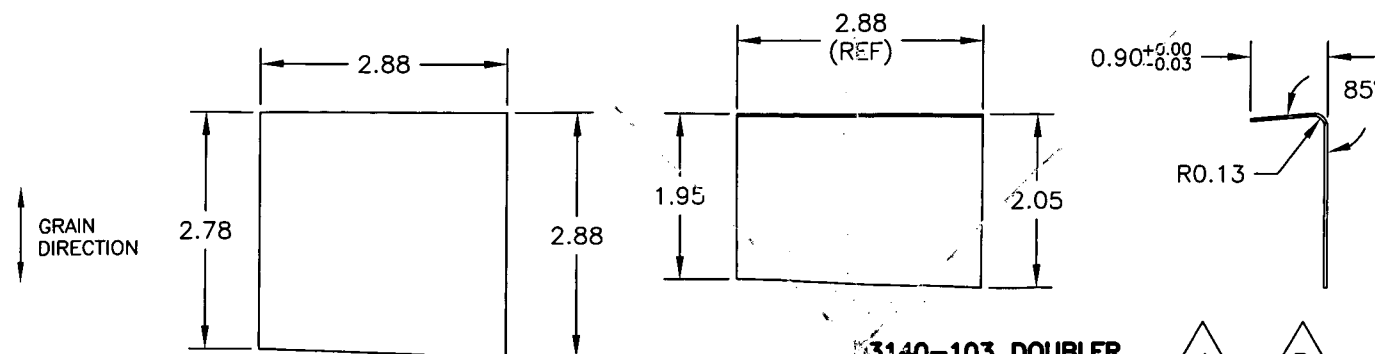
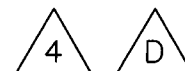


D3140-87 DOUBLER 
(REPLACES PREMIER P/N B30-23000-87)



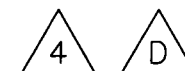
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER
D3140-106 OPPOSITE

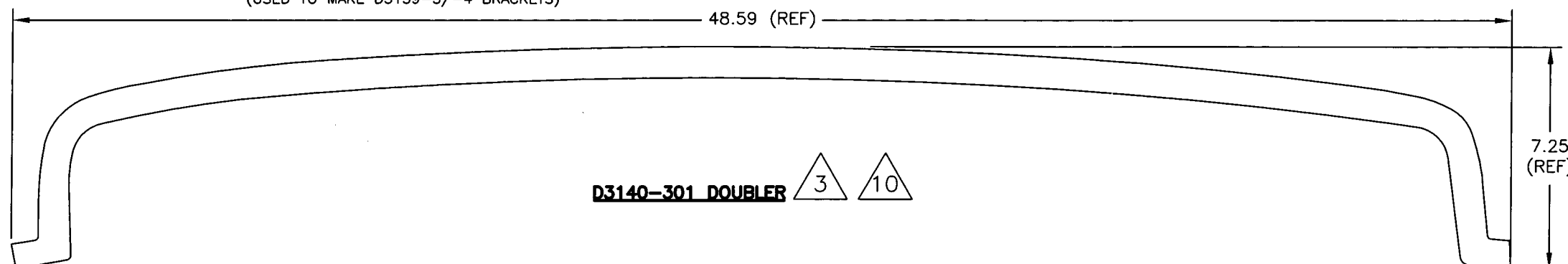


D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

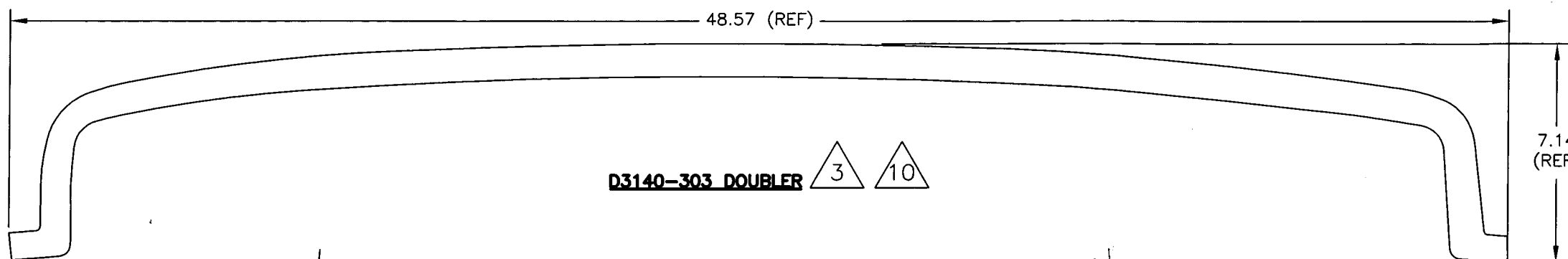
D3140-103 DOUBLER
D3140-104 OPPOSITE



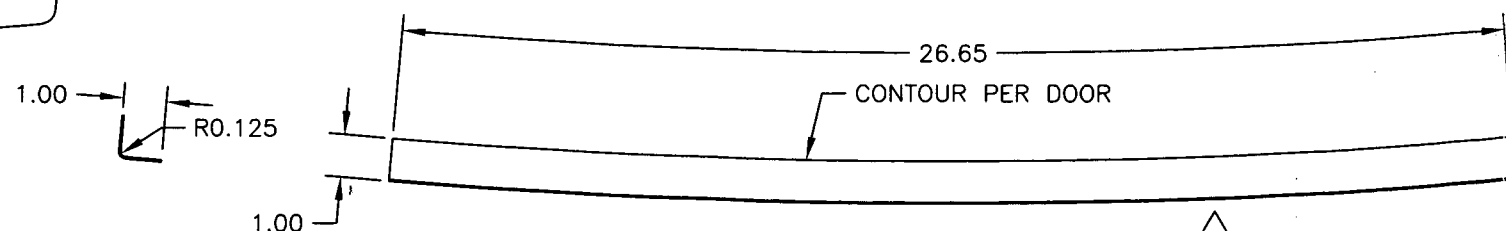
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)




D3140-301 DOUBLER  



D3140-303 DOUBLER  



D3140-85 ANGLE 
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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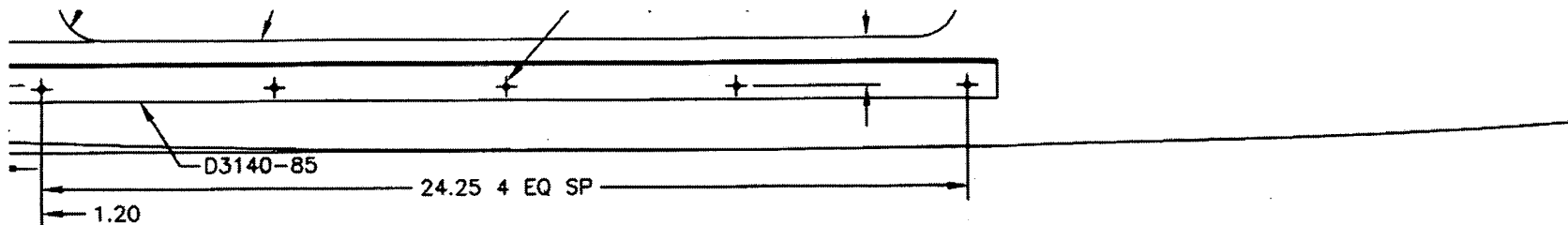
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DESIGN DS	DRAWN BY RF	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3140	REV. D SHEET 6 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

DART AEROSPACE LTD		Work Order:	
Description: Doubler Assembly		Part Number:	D3140-10
Dwg: D3140 Rev. B Pages 5,6		Qty:	
D3140-10 replaces Premier P/N B30-23000-10		Page 1 of 1	

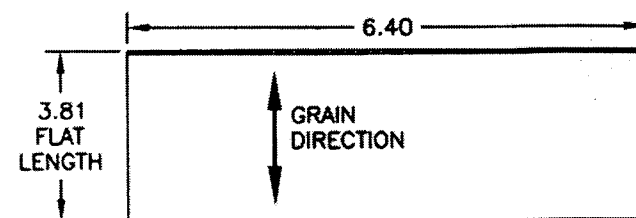
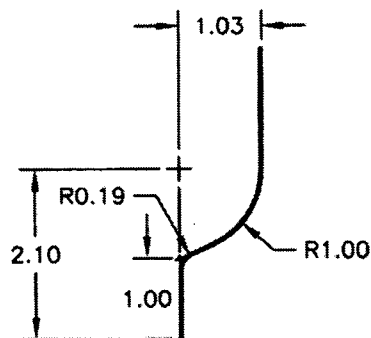
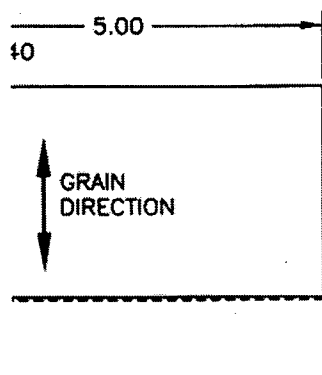
Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveller Note: D3140-10 to be made in multiples of 10.																			
2	MV	Cut blanks: 6.000" x 43.000" (+0.010/-0.000) Material: 2024-T3 (QQ-A-250/4) 0.032" thick (M2024T3S.032) Identify as D3140-89 Batch: _____																			
3	MV	Cut blanks: 26.65" x 1.90" Material: 5052-H32/H34 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Identify as D3140-85 Batch: _____																			
4	MV	Machine D3140-89 as per Folio FA226 and Dwg D3140 Stack of 10																			
5	QC2	Inspect parts as they come off the CNC machine																			
6	MV	Deburr Identify as D3140-89																			
7	QC8	Second inspection																			
8	GA	Take material for D3140-85 and Bend as per Dwg D3140																			
9	GA	Form as per Jig D3140-301T1 and Dwg D3140 and Deburr Identify as D3140-85																			
10	QC5	Inspect work to Step 9																			
11	FP	Pick D3140-89 and D3140-85 for Chemical Conversion Coat per QSI 005 4.1																			
12	QC3	Inspect Conversion Coat																			
13	GA	Place D3140-85 Angle onto D3140-89 Doubler as per Dwg D3140. **Note: D3140-10 is as shown** Transfer drill from D3140-89 Doubler into D3140-85 Angle. Hole size is 0.098" (#40). Re-alodine holes. Assemble as per Dwg D3140 <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D3140-85</td><td>Angle</td><td>_____</td></tr><tr><td>1</td><td>D3140-89</td><td>Doubler</td><td>_____</td></tr><tr><td>5</td><td>MS20426AD3-4</td><td>Rivet</td><td>_____</td></tr></table>	Qty	Part Number	Description	Batch	1	D3140-85	Angle	_____	1	D3140-89	Doubler	_____	5	MS20426AD3-4	Rivet	_____			
Qty	Part Number	Description	Batch																		
1	D3140-85	Angle	_____																		
1	D3140-89	Doubler	_____																		
5	MS20426AD3-4	Rivet	_____																		
14	QC5	Inspect 100% Kit for Completeness on the W/O																			
15	ST	Identify and Stock																			
16	AC	Cost / part																			
17	DC	Close W/O Inspect Level 21																			

Rev	Date	Change	Revised By	Approved
A	02.05.07	New issue	NG	
B	03.01.29	Incorporated material D3140-89/-85	KJ/RF	



D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)
D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)

(REPLACES P



D3140-95 DOUBLER ⁴
 (REPLACES PREMIER P/N B30-23000-95)

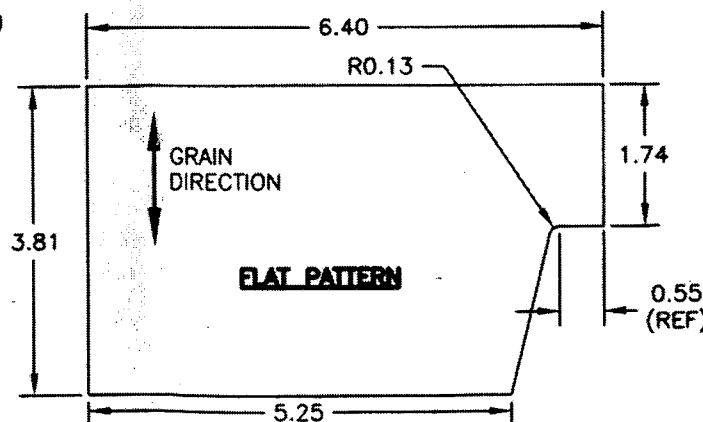
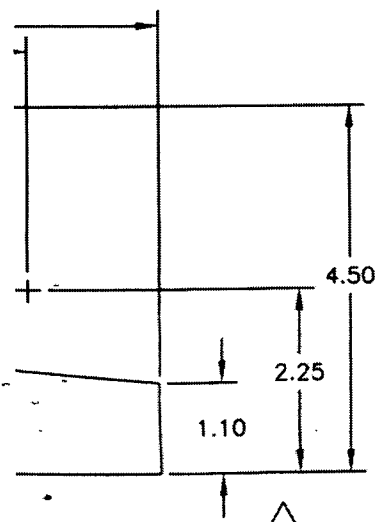
PATTERN

(-92 DOUBLERS)

(SHOWN, REPLACES PREMIER P/N B30-23000-91)

D3140-91 DOUBLER ⁴
D3140-92 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)

REFERENCE ONLY




D3140-97F FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)

D3140-97 DOUBLER
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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DESIGN DS	DRAWN BY RF	
CHECKED	APPROVED	

Linda Lacelle

From: Mélanie Godin [mgodin@delastek.com]
Sent: Wednesday, February 22, 2006 8:50 AM
To: 'Linda Lacelle'
Subject: doubler
Importance: High

Hello Linda, we have a problem with the 4 doubler # D3140-89 that I received yesterday. The doubler is not conform because there is no braket on the parts. Please confirm if you can send the good part to me and if you want that I send the wrong part to you.

Thank you !

Mélanie Godin
Delastek inc./Delastek Composites inc./
Delastek Système inc.
(819) 533-5788 ext. 249
(819) 533-7120 fax

2/22/2006

Linda Lacelle

From: Mélanie Godin [mgodin@delastek.com]
Sent: Wednesday, February 22, 2006 3:01 PM
To: 'Linda Lacelle'
Subject: RE : doubler

Hello Linda, I spoke with my engineer Stephane about that and he will prefer that we will return the doubler and you will install the braket because we don't have the appropriate equipment and we don't want have problem. Please confirm.

Thank you !

Mélanie Godin

Delastek inc./Delastek Composites inc./
Delastek Système inc.
(819) 533-5788 ext. 249
(819) 533-7120 fax

-----Message d'origine-----

De : Linda Lacelle [mailto:llacelle@dartaero.com]
Envoyé : 22 février 2006 12:48
À : 'Mélanie Godin'
Objet : RE: doubler

we will ship out the D3140-85 (bracket) along with the rivets. We will ship undrilled, so you can transfer drill from the D3140-89.

Thx
LL

-----Original Message-----

From: Mélanie Godin [mailto:mgodin@delastek.com]
Sent: Wednesday, February 22, 2006 8:50 AM
To: 'Linda Lacelle'
Subject: doubler
Importance: High

Hello Linda, we have a problem with the 4 doubler # D3140-89 that I received yesterday. The doubler is not conform because there is no braket on the parts. Please confirm if you can send the good part to me and if you want that I send the wrong part to you.

Thank you !

Mélanie Godin

Delastek inc./Delastek Composites inc./
Delastek Système inc.
(819) 533-5788 ext. 249
(819) 533-7120 fax

DART AEROSPACE LTD		Work Order:	
Description: Doubler Assembly		Part Number:	D3140-10 (2)
			-09 (2)
Dwg: D3140 Rev. B Pages 5,6		Qty:	
D3140-10 replaces Premier P/N B30-23000-10			Page 1 of 1

Step	Location	Procedure	By	Date	Qty																
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Qty	Part Number	Description	Batch																		
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16	AC	Cost / part																			
17	DC	Close W/O Inspect Level 21																			

Rev	Date	Change	Revised By	Approved
A	02.05.07	New issue	NG	
B	03.01.29	Incorporated material D3140-89/-85	KJ/RF	